

Work Order ID 135397

135397

Page 1

Wednesday, August 12, 2015 4:26:48 PM

Item ID: D3969-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Prop
 Start Date: 8/26/15 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 8/26/15 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: AUG 13 2015 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3969	C								

100 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 29489
 Order as per Dwg D3969
 Possible supplier: LS Technologies
 part#: SSA4/8-122-310-360N
 Material release note is required

0.00

CY AUG 17 2015 10
CY
NCR15-5268 AUG 25 2015 10

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

0.00

10X SP15-08-09
Pto →
NCR 15-5268

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Supplier Non-Conformance Report

Reviewed
DQA:
Date:

CLOSED

Printed on:

Tuesday, August 25, 2015

Details			
Raised Date 8/25/2015	Status Open	Owner Downing, Eric M	Number NCR15-5268
Target Date 9/18/2015	Standard		Severity
Process Inspection		Audit	
Raised By Person Berniquez, Eric	Raised Against (Department or Supplier) LS Technologies Inc.		Fault Category Supplier
Details found at inspection that PO#29489 D3969-3 B135397 prop (gas struts) require a higher force to compress. Props should compress @ 80.9 lbs but are compressing at 115 - 120 lbs.			
Keywords		Product	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 9/11/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	9/4/2015	
contact supplier and request parts to be returned & replaced. also obtain a corrective action & root cause		<i>*SEE closed NCR in Q-Pulse. 5/15/09/2.</i>	
2	Downing, Eric M	8/28/2015	
place parts in Quarantine as defective till RMA # is issued by supplier		<i>5/15/08/25 Placed in Quarantine</i>	

Verification & Review			
Target Date 9/11/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

Work Order ID 135397***135397***

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Wednesday, August 12, 2015 4:26:48 PM

Item ID: D3969-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Prop
Start Date: 8/26/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/26/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				(10)			DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									AUG 31 2015
130	Identify as per dwg & Stock Location: <u>S1368</u>	0.00				10			DAS 27 9-89
130									
Packaging	Memo	0.00							SEP 01 2015
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									SEP 02 2015

Handwritten signature **120150901**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, August 12, 2015 4:26:47 PM

Page 1

Work Order ID: 135397

135397

Parent Item: D3969-3

D3969-3

Parent Item Name: Prop

Start Date: 8/26/15

Required Date: 8/26/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
per revC DD 10.03.16 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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SSA4/8-122-310-360N

Purchased

No

110

Each

0.0000

1

10

SSA4/8-122-310-360N

Gas Spring

/OK 8/15-08-19

DQA: _____ Date: _____



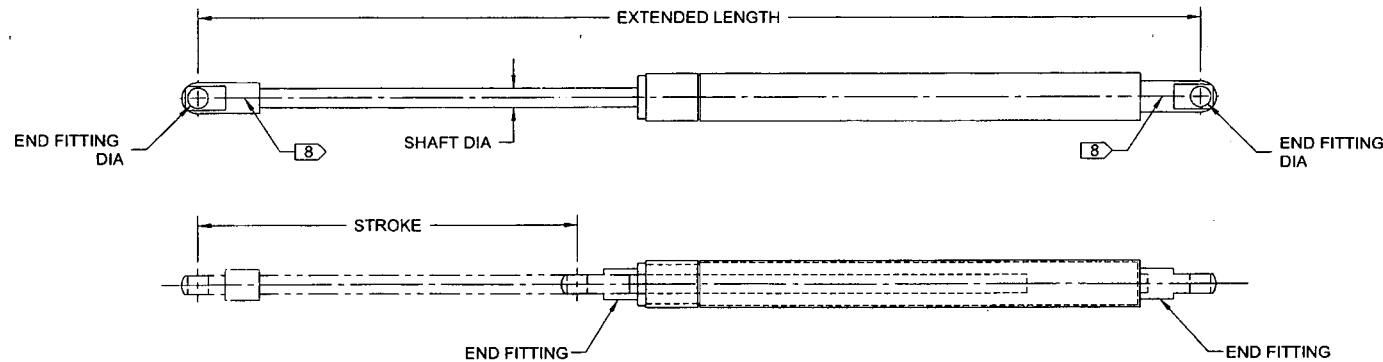
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

SPECIFICATION CONTROL DRAWING



D3969-X SPRING

DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	120/4.70	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	120/4.70	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	120/4.70	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs

- NOTES:**
- 1) MATERIAL: SEE CHART
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: SEE CHART
 - 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 135397
MLJ
1508-13

RELEASED
2010-03-12
MD

C	REDRAWN IN SW. ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 60.0 lbs).	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID). NOTE 8 ADDED.	AJS	09.11.10
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	97	DRAWING NO.	REV. C
MFG. APPR.	N/A	D3969	SHEET 1 OF 1
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	BASKET LID SPRING	NTS
DATE	10.03.04	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29489**

Purchase Order Date 8/17/2015 3:10:58 PM

PO Print Date 8/17/2015

Page Number 1 of 1

Order From :

VC-LST0001

Ship To : DART AEROSPACE LTD

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 306 683 5000

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

FedEx Overnight collect

FOB

EXW - (Ex Works)

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery-Comments						
	SSA4/8-122-310-360N	Gas Spring	8/21/2015		10.00	\$65.00	\$650.00
			Yes		Each		
			8/21/2015				
	AS PER DWG.D3969 REV. C B135397						
4	71401-45	PROCUREMENT QUALITY CLAUSES	8/21/2015		1.00	\$0.00	\$0.00
			No				
			8/21/2015				
	Procurement Quality Clauses						
	A004 faa-pma/tso						
	A005 right of entry						
	A016 personnel qualification						
	A025 certification of conformance						
	A040 notification of quality escape						
	A043 retention of quality documents						

Line Total: \$650.00

Line Total: \$0.00

PO Total: \$650.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 8/17/2015

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

P.O. No.	Date	Invoice #
29489	8/18/2015	13706

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
8/18/2015	Fed-Ex	

Qty	Description
✓ 10	D3969-3 B135397 Stainless Gas Spring (SSA4/8-122-310-360N) LABEL WITH PERMANT INK MARKER ONLY - NO LABELS Shipping Via FED EX Tracking # 774307928663 <i>SP15-08-12</i>

Order checked by: *Daniel*



LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Conformance

Aug 18, 2015

This is to certify that the parts listed below meets specifications as required by your order.

10 Units : D3969-3 B135397 Stainless Gas Spring (SSA4/8-122-310-360N)

Country of Manufacture : Canada
Date of Manufacture : August 2015
This product is ROHS compliant.

Purchase Order # 29489
Inv# 13706

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President



Supplier Non-Conformance Report

Reviewed		<i>CLOSED</i>		Printed on: Tuesday, August 25, 2015	
DQA:					
Date:					
Details					
Raised Date 8/25/2015	Status Open	Owner Downing, Eric M	Number NCR15-5268		
Target Date 9/18/2015	Standard		Severity		
Process Inspection		Audit			
Raised By Person Berniquez, Eric	Raised Against (Department or Supplier) LS Technologies Inc.		Fault Category Supplier		
Details found at inspection that PO#29489 D3969-3 B135397 prop (gas struts) require a higher force to compress. Props should compress @ 80.9 lbs but are compressing at 115 - 120 lbs.					
Keywords		Product			
Document		Root Cause			
Closed By	Closed Date	Resolution			

Corrective Action			
Target Date 9/11/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	9/4/2015	
contact supplier and request parts to be returned & replaced. also obtain a corrective action & root cause			
2	Downing, Eric M	8/28/2015	
place parts in Quarantine as defective till RMA # is issued by supplier			

return part to LS Tech. P/O: 29489 on 2015/08/25.
C/L 15/08/25

Verification & Review			
Target Date 9/11/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

P.O. No.	Date	Invoice #
29489	8/27/2015	13752

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
8/27/2015	Fed-Ex	

Qty	Description
1	Test force setting of 10 x D3969-3 B135397 Gas springs. All units found to be within specification 80 - 84 lbs at 5 mm from full extension. (360 - 375N) Shipping Via FED EX Tracking # 774384161875 15/83/ SD

Order checked by : BR



Supplier Non-Conformance Report

Reviewed
DQA:
Date: Aug 27th

Printed on: Tuesday, August 25, 2015

Raised Date 8/25/2015	Status Open	Owner Downing, Eric M	Number NCR15-5268
Target Date 9/18/2015	Standard	Severity	
Process Inspection		Audit	
Raised By Person Berniquez, Eric	Raised Against (Department or Supplier) LS Technologies Inc.	Fault Category Supplier	
Details found at inspection that PO#29489 D3969-3 B135397 prop (gas struts) require a higher force to compress. Props should compress @ 80.9 lbs but are compressing at 115 - 120 lbs.			
Keywords		Product	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Target Date 9/11/2015	Owner Downing, Eric M	Closed Date	Closed By
Details Parts tested for Force. - Found to be in Spec - 80-84 lbs			

Number	Owner	Target Date	Completed Date
Details			
1	Downing, Eric M	9/4/2015	
contact supplier and request parts to be returned & replaced. also obtain a corrective action & root cause			
2	Downing, Eric M	8/28/2015	
place parts in Quarantine as defective till RMA # is issued by supplier			

- Force testing procedure
Emailed to Eric Downing.


Nolan Fehr.

Target Date	Owner	Closed Date	Closed By
9/11/2015	Downing, Eric M		
Details			

Number	Owner	Target Date	Completed Date
Details		Response	